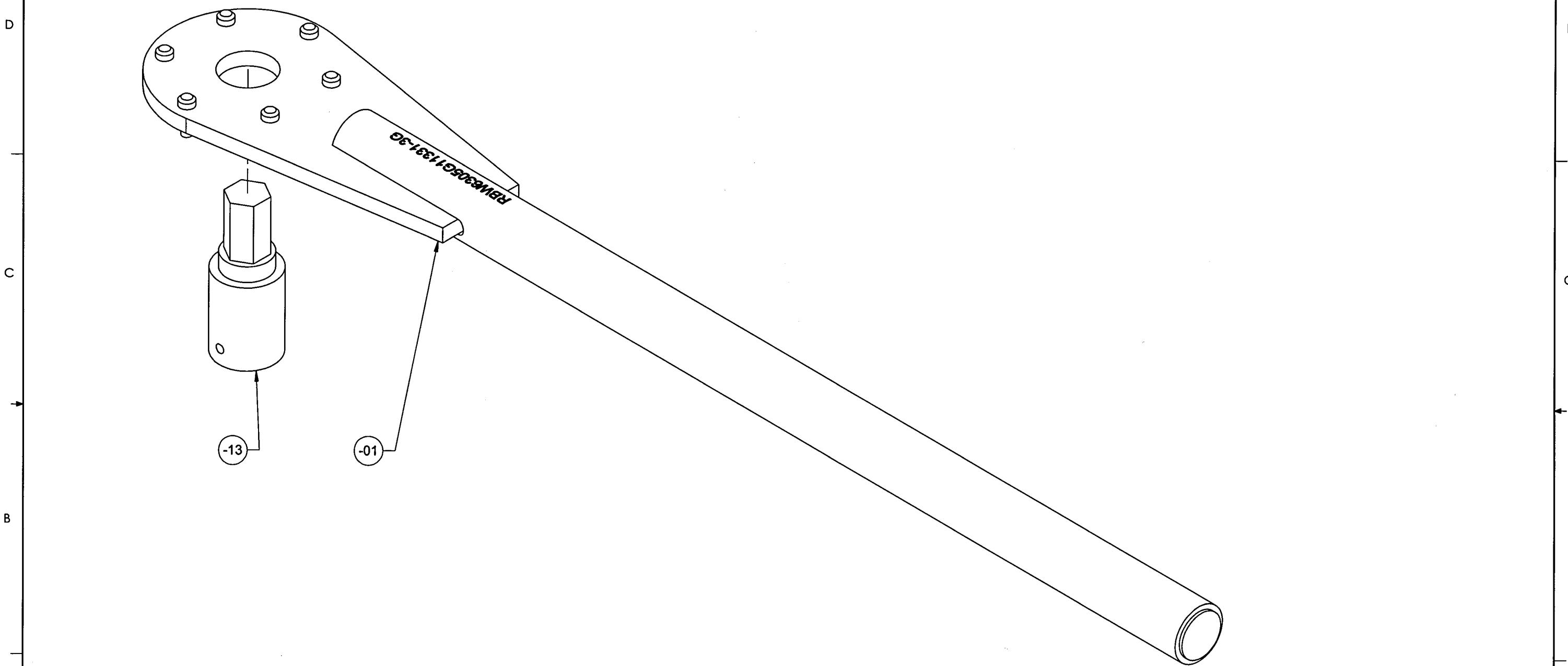


8 7 6 5 4 3 2 1

ITEM #	QTY	PART #	PART TITLE
-01	1	RBW6305G11331-3G-01	WRENCH WELDMENT
-13	1	RBW6305G11331-3G-13	SOCKET



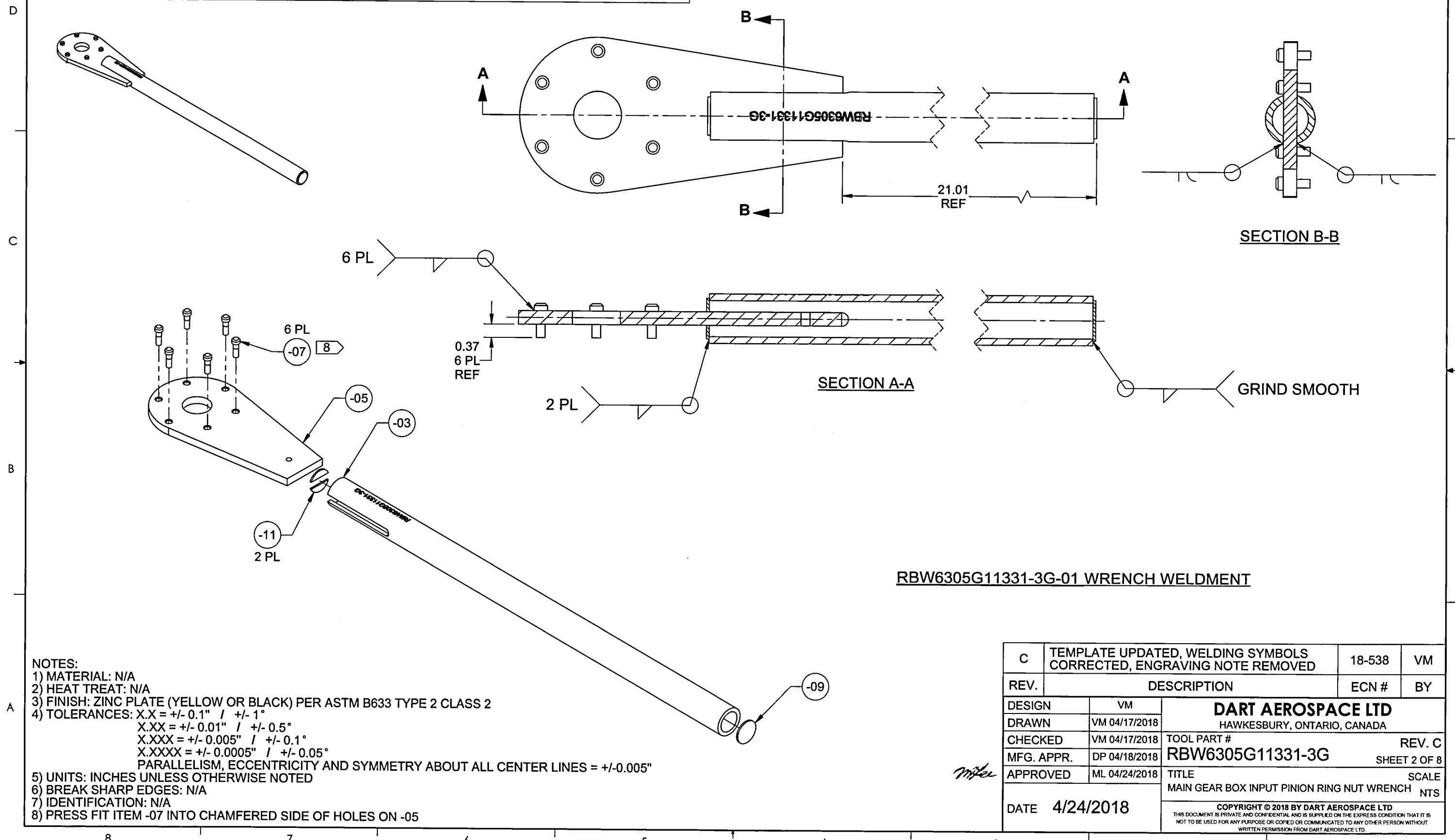
RBW6305G11331-3G MAIN GEAR BOX INPUT PINION RING NUT WRENCH

NOTES:
 1) MATERIAL: N/A
 2) HEAT TREAT: N/A
 3) FINISH: N/A
 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°

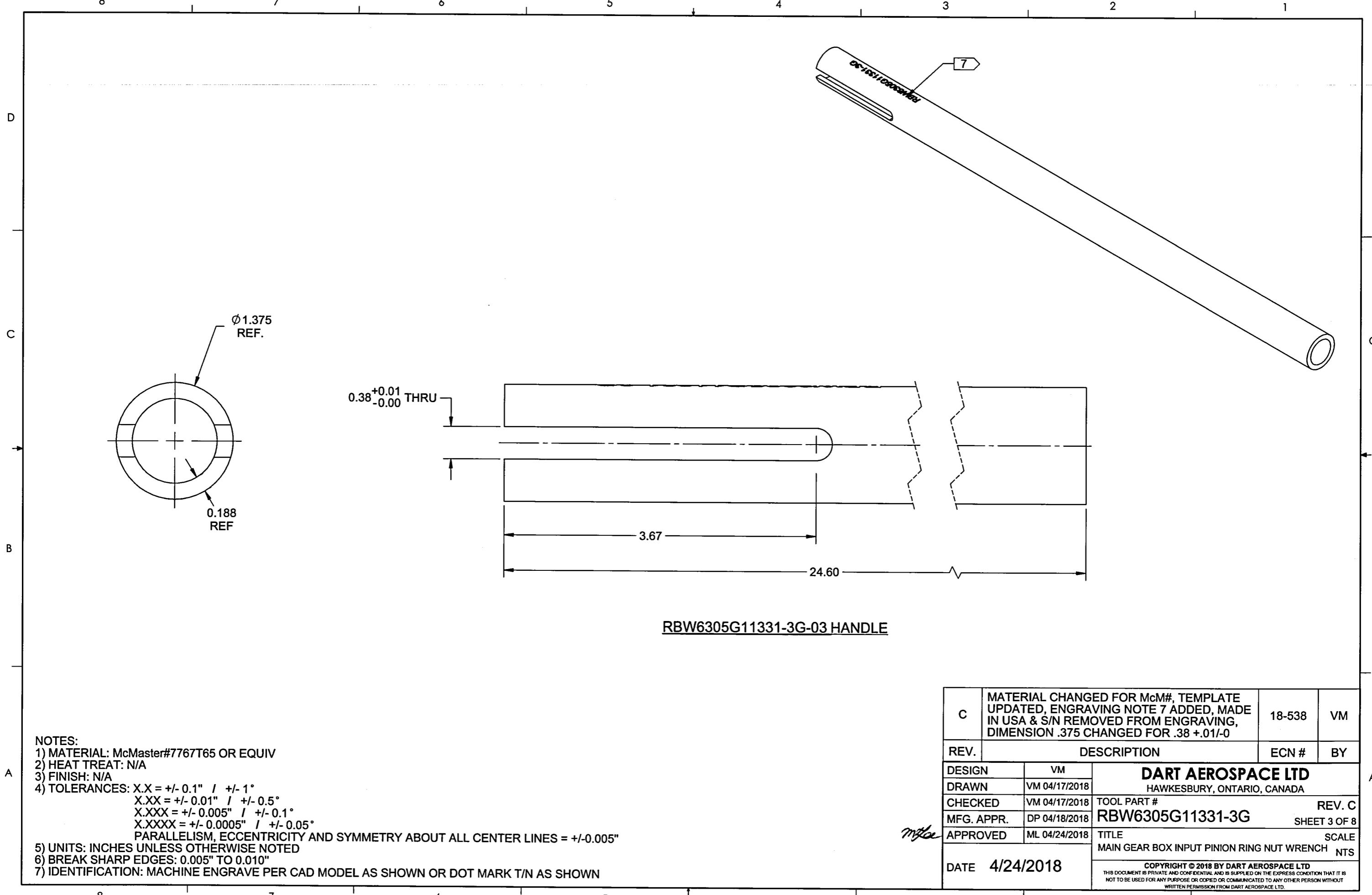
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 6) BREAK SHARP EDGES: N/A
 7) IDENTIFICATION: N/A

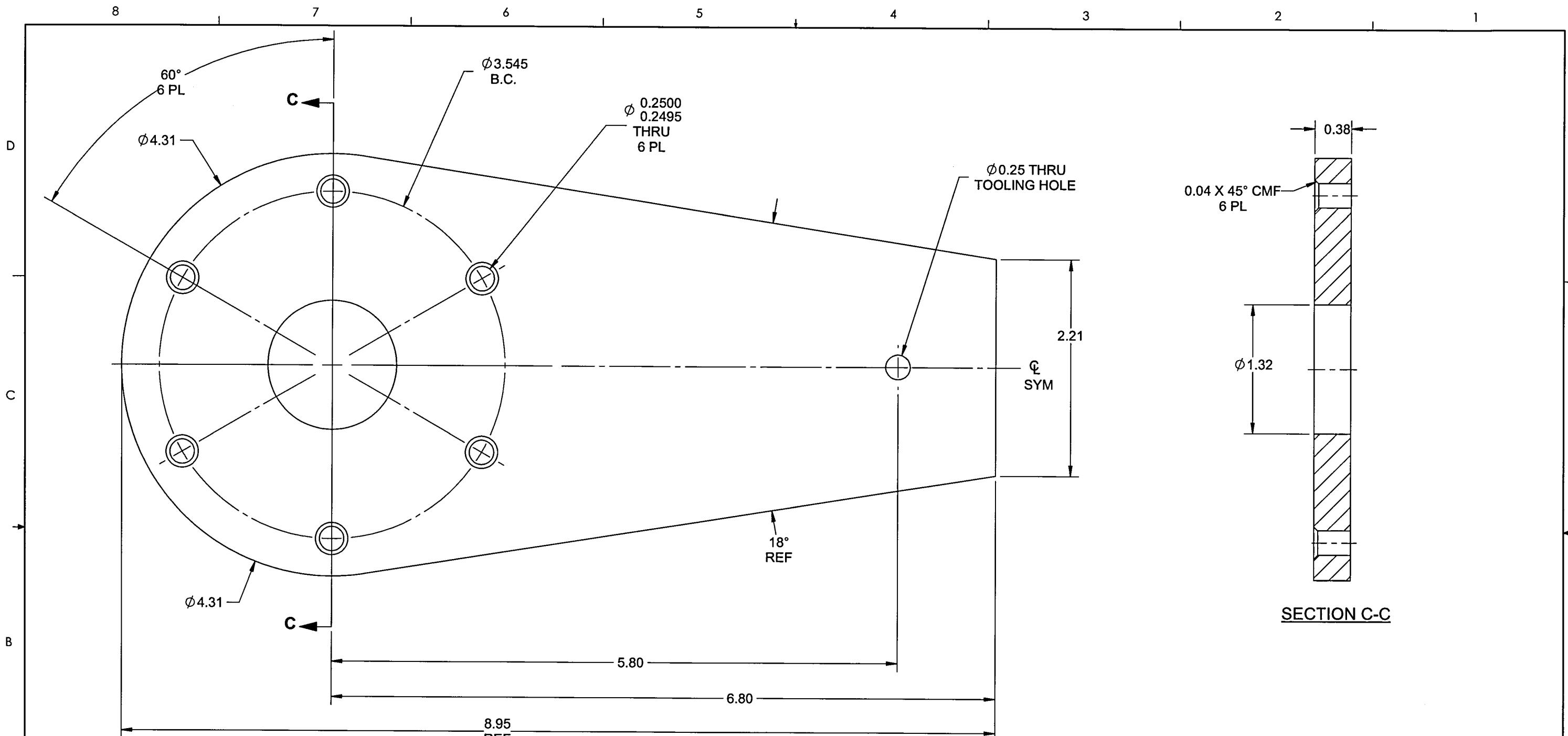
C	ITEM -13 SOCKET ADDED, TEMPLATE UPDATED	18-538	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM 04/17/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM 04/17/2018	TOOL PART #	REV. C
MFG. APPR.	DP 04/18/2018	RBW6305G11331-3G	SHEET 1 OF 8
APPROVED	ML 04/24/2018	TITLE	SCALE
		MAIN GEAR BOX INPUT PINION RING NUT WRENCH	NTS
DATE	4/24/2018	COPRIGHT © 2018 BY DART AEROSPACE LTD	
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ITEM #	QTY	PART #	PART TITLE
-03	1	RBW6305G11331-3G-03	HANDLE
-05	1	RBW6305G11331-3G-05	PLATE
-07	6	RBW6305G11331-3G-07	LUGS
-09	1	RBW6305G11331-3G-09	END CAP
-11	2	RBW6305G11331-3G-11	END CAP HALF

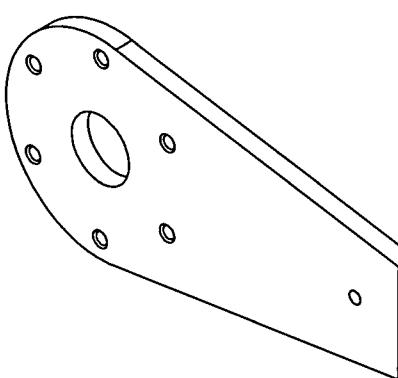


C	TEMPLATE UPDATED, WELDING SYMBOLS CORRECTED, ENGRAVING NOTE REMOVED	18-538	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM		
DRAWN	VM 04/17/2018		
CHECKED	VM 04/17/2018	TOOL PART #	REV. C
MFG. APPR.	DP 04/18/2018	RBW6305G11331-3G	SHEET 2 OF 8
APPROVED	ML 04/24/2018	TITLE MAIN GEAR BOX INPUT PINION RING NUT WRENCH NTS	SCALE
DATE	4/24/2018	COPRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	





RBW6305G11331-3G-05 PLATE



NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X X = +/- 0.1" / +/- 1°

4) TOLERANCES: X.X = +/- 0.1° / +/- 1°
 X.XX = +/- 0.01° / +/- 0.5°
 X.XXX = +/- 0.005° / +/- 0.1°
 X.XXXX = +/- 0.0005° / +/- 0.01°
 PARALLELISM, ECCENTRICITY

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

C	TEMPLATE UPDATED, DIMENSION 3.545 B.C ADDED, SYMBOL CL SYM ADDED, DIMENSION 8.95 CHANGED FOR REF AND DIMENSION 6.80 ADDED			18-538	VM
REV.	DESCRIPTION			ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	VM 04/17/2018				
CHECKED	VM 04/17/2018	TOOL PART #		REV. C	
MFG. APPR.	DP 04/18/2018	RBW6305G11331-3G		SHEET 4 OF 8	
APPROVED	ML 04/24/2018	TITLE		SCALE	
		MAIN GEAR BOX INPUT PINION RING NUT WRENCH		NTS	
DATE 4/24/2018		COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

8 7 6 5 4 3 2 1

D

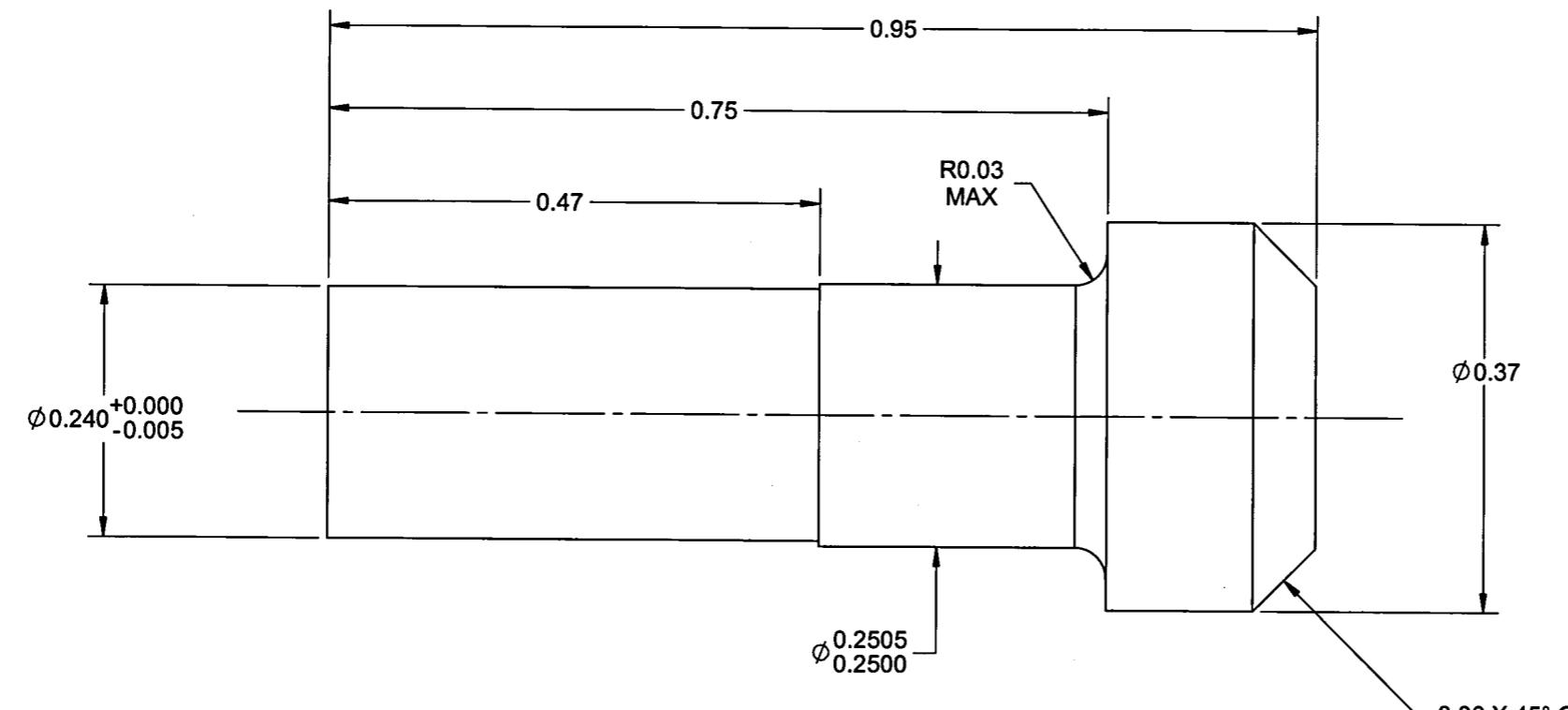
D

C

C

B

B



RBW6305G11331-3G-07 LUGS

NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: 30-35 Rc
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

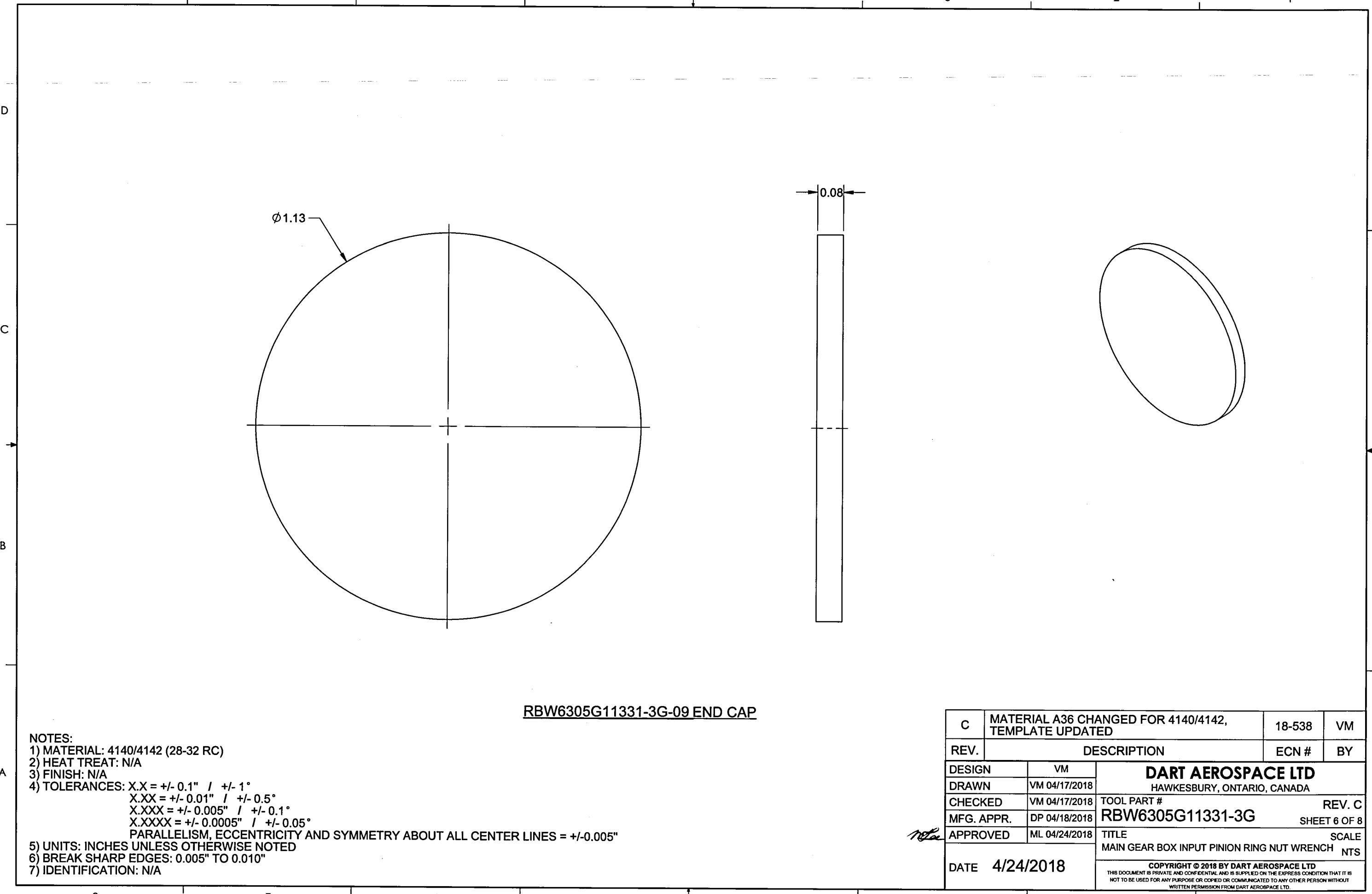
C	TEMPLATE UPDATED, DIMENSION .242 +.001/-0 CHANGED FOR .2500/.2505, DIMENSION .240 +/-.002 CHANGED FOR .240 +0/-0.005			18-538	VM
REV.	DESCRIPTION			ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			A
DRAWN	VM 04/17/2018				
CHECKED	VM 04/17/2018	TOOL PART #			C
MFG. APPR.	DP 04/18/2018	RBW6305G11331-3G			SHEET 5 OF 8
APPROVED	ML 04/24/2018	TITLE MAIN GEAR BOX INPUT PINION RING NUT WRENCH NTS			SCALE
DATE 4/24/2018		COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

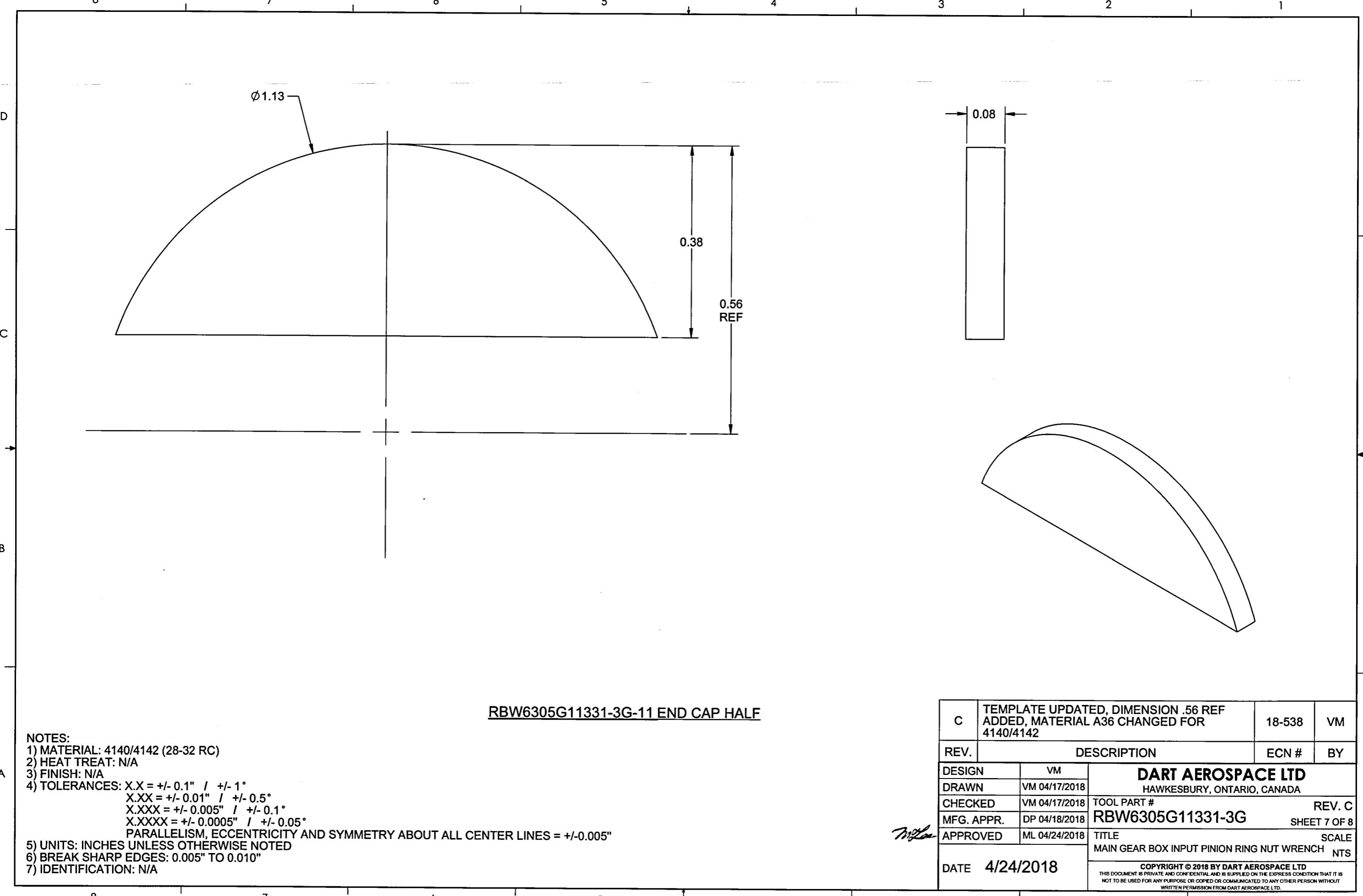
8 7 6 5 4 3 2 1

A

A

1





8 7 6 5 4 3 2 1

D

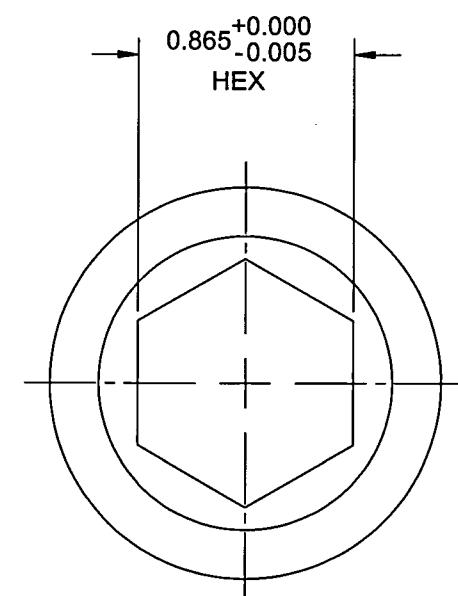
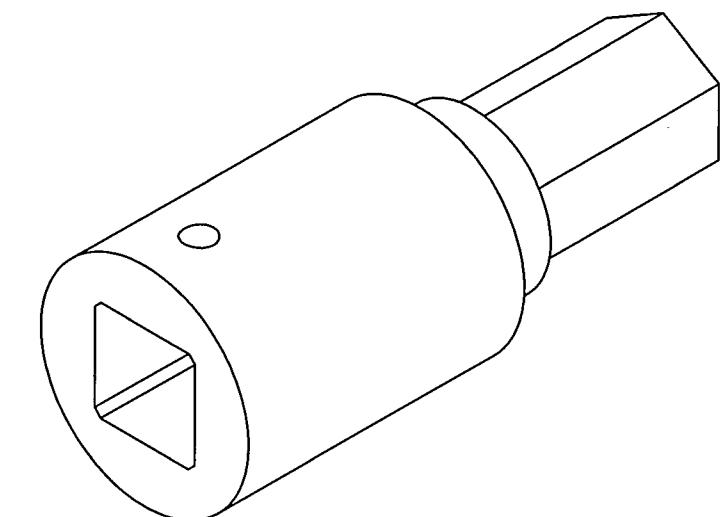
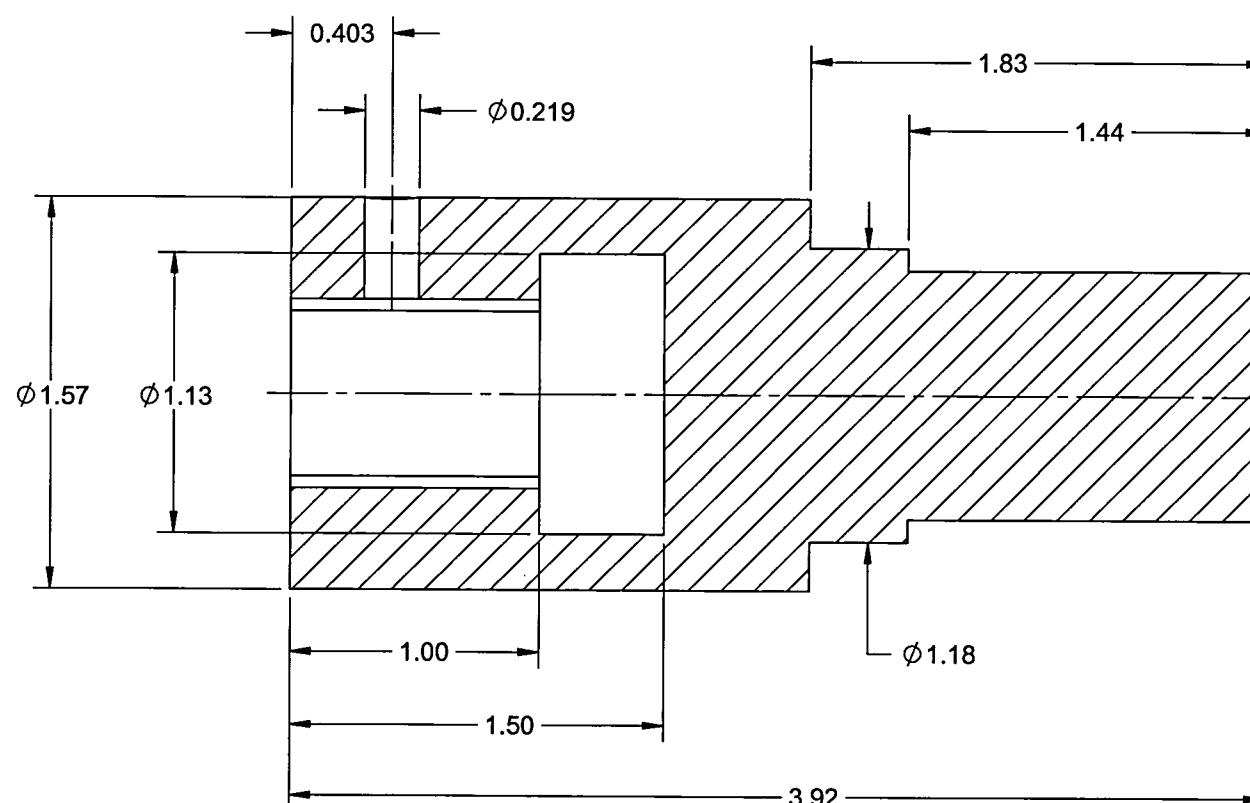
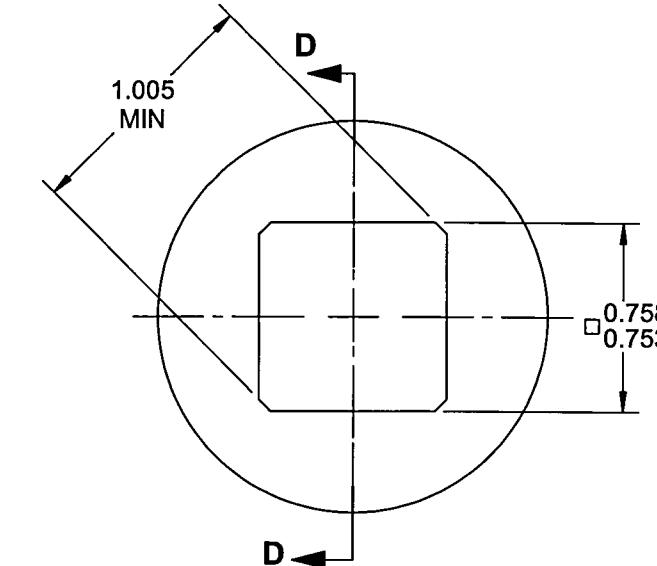
D

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RBW6305G11331-3G-13 SOCKET

SECTION D-D

NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005" TO 0.010"

7) IDENTIFICATION: N/A

C	MISSING PART ADDED		18-538	VM
REV.	DESCRIPTION		ECN #	BY
DESIGN	VM			
DRAWN	VM 04/17/2018			
CHECKED	VM 04/17/2018	TOOL PART #		
MFG. APPR.	DP 04/18/2018	RBW6305G11331-3G	REV. C	
APPROVED	ML 04/24/2018	TITLE		
		MAIN GEAR BOX INPUT PINION RING NUT WRENCH		
		NTS		
	DATE	4/24/2018	COPYRIGHT © 2018 BY DART AEROSPACE LTD	
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M. Lee

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12 JUN 18

DQA:

Date: 17 MAY 2018



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____	DISPOSITION		
Part No. RBW6305G11331-3G	Rework	Skid-tube	Cross tube
	Scrap	Machining	Small Fab
NCR No.	Use-as-is	Thermoforming	Finishing
	Suspected Unapproved	Large Fab	Composite

AGAINST DEPARTMENT/PROCESS

Water Jet	<input type="checkbox"/>	Engineering	<input type="checkbox"/>
Prod. Eng. Coor.	<input type="checkbox"/>	Quality	<input type="checkbox"/>
Rec/Store/Packaging	<input type="checkbox"/>	Other	<input type="checkbox"/>

Date : _____	Step #:	QTY Effective :	MRB (QSI042) Approval <i>[Signature]</i>
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Description Work Order Deviation	Disposition	Completed By
MATERIAL TYPE TO BE CHANGED FOR - RBW6305G11331-3G-09 END CAP - RBW6305G11331-3G-11 END CAP HALF - REVISE MATERIAL FROM 4140/4142(28-32 Rc) TO 4130	- THIS DEVIATION IS ACCEPTABLE - THE FIT, FORM AND FUNCTION OF THE PART WILL BE AS ORIGINALLY INTENDED.	Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval

Root Cause		FAULT CATEGORY									
Environment	<input type="checkbox"/>	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong					
Design	X	Operator	Bending	Set-up	Folio/Program	Outside Dimensions					
Doc/Data	<input type="checkbox"/>	Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance					
Equip/Tooling	<input type="checkbox"/>	Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect					
Handling/Pre	<input type="checkbox"/>	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing					
Material	<input type="checkbox"/>	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved					
Internal Transport	<input type="checkbox"/>	Poor Information	Crushing	Countersink	Off-set	Drawing					
Tribal Knowledge	<input type="checkbox"/>	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish					
LOA	<input type="checkbox"/>	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread					
Substation	X	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence					
Past Expiry Date	<input type="checkbox"/>	Manufacturing Process	OTHER :								
Misidentified	<input type="checkbox"/>	Past Due									